| Work Ord <i>July 28, 2009</i> | | 9 7 4 | l | | · | | | | | | | | | Page |
|--|----------------------------|--------------|---------------------------------|-------|---|----------------------|----------------------------|--------------|--------------|--------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D2221 H 350 Basket B | ase | | | | Accept | | | | | Setup | Start Stop | | |
| Start Date: Required Date Reference: | 7/30/09 e: 8/07/09 | i | art Qty: 1.00 eq'd Qty: 1.00 | ï | 1 | | Cust Item ID: Customer: | | | | | | | |
| Approvals: | Process Pl | an: _ | W | Date: | | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | | |
| Sequence ID/ Work Center | ID | | eration scription | | | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| Draw Nbr D2221 | Re ^o | | n Nbr | | | | | | | | | | | |

100

Large Fab Large Fab

Large Fab

Memo

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch:

0.00

0.00

Mogloslo6 (lx)

110

QC

Quality Control

Memo

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

| Dart Ae | rospace | Ltd | | | | | | | A |
|---------|---------|-------------------|--|---------------------------|------------|-------------------------------------|--------------------------|-----------|--------------|
| W/O: | | | W | ORK ORDER CHANGI | ES | | | | |
| DATE | STEP | PRO | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| | | | | | | | | | |
| | | | | | | | | | |
| Part No | : | PAR #: | Fault Cat | egory: | NCR: Ye | s No DC | A: | _ Date: _ | |
| | Re | solution: | Dispositi | on: | _ QA: N/C | Closed: | | Date: _ | |
| NCR: | | \ | WORK ORI | DER NON-CONFORMA | NCE (NC | R) | | | |
| DATE | 0 | Description of NC | | Corrective Action Section | Section B | | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Action Description Chief Eng Chief Eng | | Sigr Da | 1& Sec | tion C | Chief Eng | QC Inspector |
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| Work Order ID 509 | 74 |
|-------------------|----|
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July 28, 2009 1:52:56 PM



Page 2

Item ID:

D2221

Revision ID: Η

Item Name: 350 Basket Base

Start Date: 7/30/09 Required Date: 8/07/09

Req'd Qty: 1.00

Start Qty: 1.00



Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date: _____

Date: **Tooling:**

SPC (Y/N):

Date: Date: Run

Start

Stop



Set Up/

Draw Number

Draw Rev.

Accept **Qty**

Reject **Oty**

Reject Insp. Number Stamp

Work Center ID 120

Sequence ID/

Quality Control

Operation **Description**

QC6- Inspect dimensions to drawing

Memo

Run Hours

0.00

0.00

0.00

0.00

Plan

Code

130



Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

* PRESSUR (-WASH *

09-08-06 EUN



Memo

1- Plug holes prior to M117260

1ST COAT:

START TIME: 10:15Am OVEN TEMPERATURE: 400° (=

2ND COAT:

START TIME: 1):00 AVOO 1-FINISH TIME: 11:30A

M (800-80-80-80

| Dart | Aeros | pace | Ltd |
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| W/O: | | | WC | ORK ORDER CHANG | GES | | | | |
| DATE | STEP | PRC | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | 1998 5 - 75 | | | | | | |
| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | _ Date: _ | |
| | Res | solution: | Dispositio | n: | QA: N/C (| Closed: | | Date: _ | |
| NCR: | | \ | WORK ORD | ER NON-CONFORM | ANCE (NC | R) | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Corrective Action Sec Action Description Chief Eng | ction B Sign Date | & Sect | cation ion C | Approval Chief Eng | Approval QC Inspector |
| | | · · · · · · · · · · · · · · · · · · · | Office Ling | Office Eng | | | | | |
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| V1-5 | | 1 | | | | | *************************************** | | |
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Work Order ID 50974

July 28, 2009 1:52:56 PM



Page 3

Item ID:

D2221

Н

Revision ID: Item Name:

350 Basket Base

Start Date:

7/30/09

QC:

Start Qty: 1.00

Reg'd Qty: 1.00



Accept



Cust Item ID:

Customer:

Draw

Number

Setup Start



Stop

Required Date: 8/07/09

Approvals:

Reference:

Process Plan:

Tooling: Date:

Date:_____ SPC (Y/N):

Date:

Date:

Draw

Rev.

Plan

Code

Start Run

Reject

Qty



Insp.

Stamp

Stop

Reject

Number

Sequence ID/ **Work Center ID**

140

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

Set Up/ **Run Hours**

0.00

24-08-6 D.

Accept

Qty

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

| Dart Ae | rospace | : Ltd | | | | | | • |
|---------|---------|-------------------|----------------------|------------------------------|----------------|-------------------------------|--------------------------|--------------------------|
| W/O: | | | W | ORK ORDER CHANGE | S | | | |
| DATE | STEP | PRO | CEDURE CH | Ву | Date Q | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | · | |
| | | | | | | | | |
| | | | | | | | | |
| Part No | : | PAR #: | Fault Cate | egory: | NCR: Yes | No DQA: _ | Date: _ | |
| | Re | esolution: | Dispositi | on: | QA: N/C Cld | sed: | Date: _ | |
| NCR: | | V | VORK ORE | DER NON-CONFORMAN | NCE (NCR |) | | |
| | T | Description of NC | | Corrective Action Section | n B | Verificati | on Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | Approval QC Inspector |
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| W/O: | | | WO | RK ORDER CHANG | SES | | | | | |
| DATE | STEP | PRO | PROCEDURE CHANGE | | | | | | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Categ | jory: | _ NCR | :Yes N | lo DQ | A : | _ Date: _ | |
| Resolution: | | | Disposition |); | QA: | N/C Clo | sed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORM | ANCE | (NCR) |) | | | |
| DATE | STEP | Description of NC | | | Section B Verifica | | | | Approval | Approval |
| DAIL | JILI | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | on C | Chief Eng | QC Inspector |
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July 28, 2009 1:52:55 PM

Work Order ID: 50974

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Manufactured

No

Comments:



Start Date: 7/30/09

Required Date: 8/07/09

Page 2

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2232-3RevC | 1 | Manufactured | No | | | 100 | Each | 7.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |

Basket Hinge

| <u>Warehouse</u> | Loc | <u>Oty</u> | Loc Code | | | | | |
|------------------|-----|------------|----------|--------|--|--|--|--|
| Location | | | | | | | | |
| Main Warehouse | | | | | | | | |
| ST | | 11 | | | | | | |
| 48443 | | 6 | | | | | | |
| 50024 | | 5 | | | | | | |
| | 100 | Each | 7.0000 | 2.0000 | | | | |

-2x 2409/04/29

Basket Rib

D2235-1RevB1

| Warehouse | Loc Oty | Loc Code |
|-----------------|---------|----------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 4 | |
| 48665 | 2 | |
| 50029 | 2 | |
| Main Warehouse | | |
| WA | 7 | |

50565

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | | | |
|-------------|------|--------------------|----------------------|------------------------------|--------------|----------------|-------|--------|-----------|--------------------------|--|--|--|--|
| DATE | STEP | PRO | PROCEDURE CHANGE | | | | | | | Approval QC Inspector | | | | |
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| Part No | | PAR #: | | | | | | | | | | | | |
| Resolution: | | | Disposition |): | QA: | N/C Clo | sed: | | Date: | - | | | | |
| NCR: | | | WORK ORDE | ER NON-CONFORM | IANCE | (NCR |) | | | • | | | | |
| DATE | STEP | Description of NC | | | Section B | | | cation | Approval | Approval | | | | |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | า | Sign & Date | Secti | | Chief Eng | QC Inspector | | | | |
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July 28, 2009 1:52:55 PM

Work Order ID: 50974

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Manufactured

No

Comments:



Start Date: 7/30/09

Required Date: 8/07/09

Page 3

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2581RevA1 | | Manufactured | No | | | 100 | Each | 7.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |

Mounting Bracket

| Loc | e Oty | Loc Code | | | 0 1 |
|-----|-------|---------------|--------|--------|--|
| | 12 = | ~ ~~ - | | | $\mathcal{L}\mathcal{M}$ |
| | 550 | 78,45 | | ax | 09/08/05 |
| | 15 | | | | , -, - |
| | 2 | | | | |
| | 13 | | | - | |
| 100 | Each | 12.0000 | 2.0000 | | |
| | | | | • | • |
| | | 15 2 13 | B50872 | B50872 | B50872 2x 15 2 13 100 Each 12.0000 2.0000 |

Shim

D3442-1RevA

| Warehouse | Loc Oty | Loc Code | |
|-----------------|---------|----------|------------|
| Location | | | |
| Main Warehouse | | | |
| ST | 16 | | |
| 46767 | 1 | | |
| 47074 | 5 | | |
| 50023 | 10 | | ax Maloyla |



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|---------|----------|-------------------|----------------------|--|--------|------------------|--------------|------------|-------------------------------|--------------------------|
| W/O: | | | RK ORDER CHANG | SES | | | | | | |
| DATE | STEP | PRO | OCEDURE CHA | NGE | E | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | jory: | _ NCR: | Yes N | lo DQ | 4 : | _ Date: _ | |
| | Re | esolution: | 1: | QA: N | /C Clo | sed: | | Date: _ | | |
| NCR: | | | WORK ORDI | ER NON-CONFORM | ANCE (| NCR) | | | | |
| DATE | OTED | Description of NC | <u> </u> | | tion B | VATI | | | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Section (| | | Chief Eng | QC Inspector |
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July 28, 2009 1:52:55 PM

Page 4

Work Order ID: 50974

Parent Item:

Comments:

D2221RevH

Parent Item Name: 350 Basket Base



No

Loc Code

Start Date: 7/30/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3825-041RevA | 1 | Manufactured | No | | | 100 | Each | 6.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |

Rib Assembly (Basket End)

| Warehouse | Loc | : Qty | Loc Code | | | |
|-----------------|-----|-------|----------|--------|--|--|
| Location | | | | | | |
| Main Warehouse | | | | | | |
| ST | | 4 | | | | |
| 48668 | | 4 | | | | |
| Main Warehouse | | | | | | |
| WA | | 6 | | | | |
| 50582 | | 6 | | | | |
| | 100 | Each | 8.0000 | 2.0000 | | |



Rib / Gusset Assembly

D3826-041RevB

| Warehouse Location | Loc Qty |
|--------------------|---------|
| Main Warehouse | |
| ST | 2 |
| 48644 | 2 |
| Main Warehouse | |
| WA | 8 |
| 50028 | 2 |
| 50607 | 6 |

| Dart Aerospace L | _td |
|------------------|-----|
|------------------|-----|

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|---------|------|-------------------|--------------------|---------------------------------------|------------|--------------|--------|-------------------------------|--------------------------|--|--|--|
| W/O: | | | WORK ORDER CHANGES | | | | | | | | | |
| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No | : | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DQ | A: | Date: | | | | |
| | Res | solution: | | | | | | Date: _ | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | ANCE (NC | R) | | | | | | |
| DATE | STEP | Description of NC | Initial | Corrective Action Section Description | on B | | cation | Approval | Approval | | | |
| | | Section A | Chief Eng | Chief Eng | Date | | on C | Chief Eng | QC Inspector | | | |
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July 28, 2009 1:52:55 PM

Work Order ID: 50974

D2221RevH

Parent Item Name: 350 Basket Base

Manufactured

No

Comments:

Parent Item:



Start Date: 7/30/09

Required Date: 8/07/09

Page 5

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3827-041RevA | | Manufactured | No | | | 100 | Each | 2.0000 | 1.0000 | | | |
| | | | | | | | | | | | | |

Rib Assembly (Inboard)

D3832-1RevA

| <u>Warehouse</u> | <u>Lo</u> | c Oty | Loc Code | |
|------------------|-----------|-------|----------|--------|
| Location | | | | |
| Main Warehouse | | | | |
| ST | | 4 | | |
| 48454 | | 4 | | |
| | 100 | Each | 5.0000 | 1.0000 |

Loc Code

Jx Sy 09/04/29

Mesh (Base)

Warehouse Loc Qty Location Main Warehouse ST 2 46306 46774 Main Warehouse WA50564 3

1x Moglo4/30

| Dail 710 | oopaoc | | | | | | | | |
|----------|--------|-------------------|----------------------|------------------------------|--------------|---------|------------|-------------------------------------|--------------------------|
| W/O: | | | WO | RK ORDER CHANG | GES | | | | |
| DATE | STEP | PRO | OCEDURE CHAN | IGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
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| Part No | : | PAR #: | Fault Categ | ory: | NCR: Yes | No DQ | A : | Date: _ | |
| | Re | esolution: | Disposition | : | QA: N/C (| closed: | | Date: _ | |
| NCR: | | , | WORK ORDE | R NON-CONFORM | ANCE (NC | R) | | | |
| DATE | STEP | Description of NC | | | tion B | Verific | ation | Approval | Approval |
| | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | | on C | Chief Eng | QC Inspector |
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July 28, 2009 1:52:55 PM

Page 6

Work Order ID: 50974

Parent Item:

D2221RevH

Parent Item Name: 350 Basket Base

Comments:



Start Date: 7/30/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3833-1RevA | | Manufactured | No | | | 100 | Each | 6.0000 | 2.0000 | | | |
| | | | | | | | | | | | | |

Mesh (Base End Face)

| Warehouse | Loc Qty | Loc Code | |
|-----------------|---------|----------|---------------|
| Location | | | |
| Main Warehouse | | | |
| ST | 4 | | |
| 48646 | 4 | | |
| Main Warehouse | | | |
| WA | 6 | | |
| 50025 | 6 | | 2x M 00/04/30 |

| W/O: | - | | WC | RK ORDER CHANG | ES | | | | | |
|-----------------|-----------|-------------------|-----------------------------|--|--------------|--------|------------|-------------------------------------|--------------------------|--|
| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | The section of the se | | | | | | |
| Part No: PAR #: | | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DQ | A : | Date: | | |
| Resolution: | | | Disposition | າ: | _ QA: N/C C | losed: | | Date: _ | | |
| NCR: | | , | WORK ORDI | ER NON-CONFORMA | NCE (NCI | R) | | | | |
| DATE | STEP | Description of NC | Corrective Action Section B | | | | cation | Approval Chief Eng | Approval | |
| | Section A | | Initial Chief Eng | Action Description Chief Eng | Sign of Date | | ion C | | QC Inspector | |
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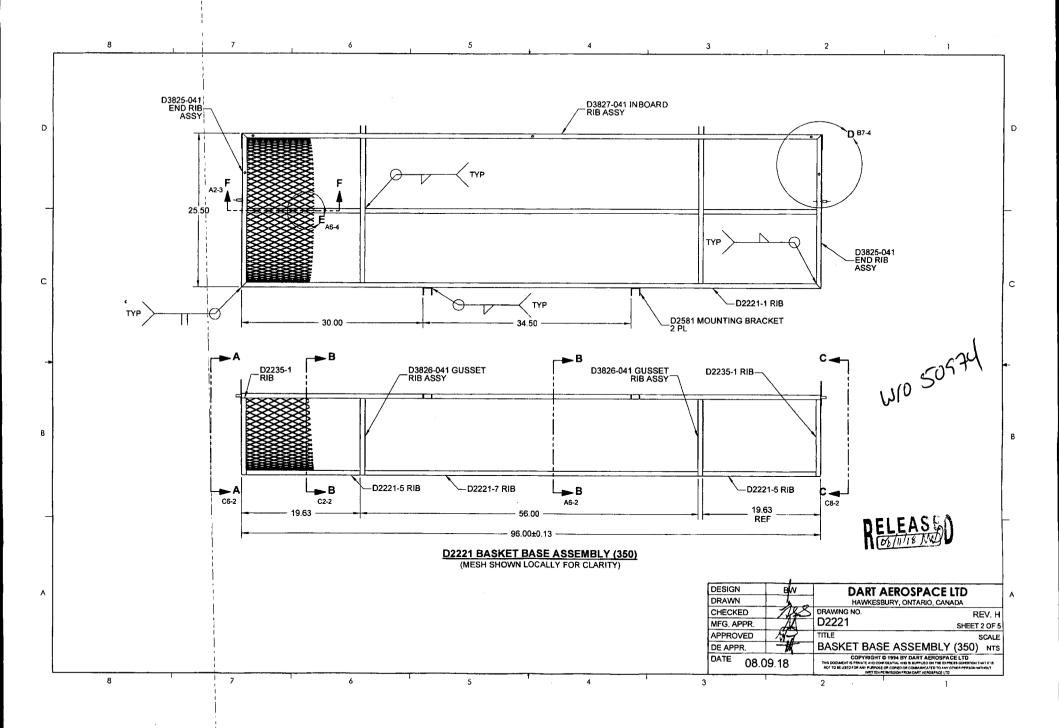
D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY) NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

| | | i | |
|------|---|--|--|
| ITEM | QTY | P/N | DESCRIPTION |
| 1 | X | D2221 | BASKET BASE ASSEMBLY (AS350) |
| 2 | 1 | D2221-1 | RIB |
| 3 | 2 | D2221-5 | RIB |
| 4 | 1 | D2221-7 | RIB |
| 5 | 2 | D2232-3 | BASKET HINGE |
| 6 | 2 | D2235-1 | RIB |
| 7 | 2 | D2581 | MOUNTING BRACKET |
| 8 | 2 | D3442-1 | SHIM |
| 9 | 2 | D3825-041 | RIB ASSY (BASKET END) |
| 10 | 2 | D3826-041 | RIB/GUSSET ASSY |
| 11 | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 12 | 2 | D3833-1 | MESH, BASE END FACE |
| 13 | 1 | D3832-1 | MESH (BASE) |
| | 1 2 3 4 5 6 7 8 9 10 11 | 1 X 2 1 3 2 4 1 5 2 6 2 7 2 8 2 9 2 10 2 11 1 12 2 | 1 X D2221 2 1 D2221-1 3 2 D2221-5 4 1 D2221-7 5 2 D2232-3 6 2 D2235-1 7 2 D2581 8 2 D3442-1 9 2 D3825-041 10 2 D3827-041 11 1 D3827-041 12 2 D3833-1 |

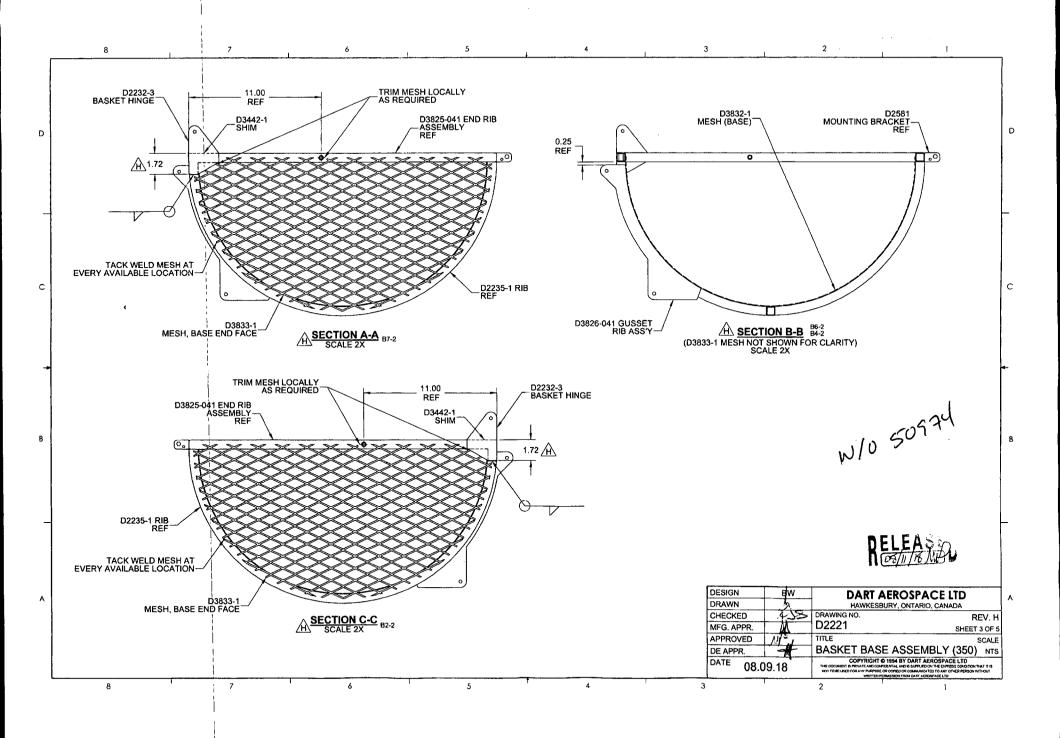
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| н | PARTS C-C (ZN 4); ADDI (ZN B2-4 (SHEET ZN B4-3 041 REF D2221-1 | LIST (ZN D3-1); C6-3, C2-3 AN ED DETAIL E (2 I); ADDED DWG 5); TOL REVIS); D3825-041 R PLACES D2235 ON INBOARD | AND ADDED "TEM" COLLIMN TO REVISED SECTIONS A.A. B-I AND D AB-3): REVISED DETAIL D (ZN B7- NA 6-4): ADDED SECTION F-F 3 DETAILS FOR D221-1-5-7- ED TO 2 DEC PLACES (ZN B-3 AND EPLACES D2221-3/D2327-3; D3326- 1/D2325; D3827-041 REPLACES SIDE: ADDED D3821-1 AND D3833-1. AN MANUFACTURING" PROGRAM. | мв | 08.09.18 | | | |
| G | TOLERA WAS RE NOW "R TO SHT | AL FOR -1, -3, INCE FOR 96.0 F (ZN B5-2); 19 EF" (ZN B4-2); 2; SHT 2 MESH ERED TO "B" I | AJS | 08.06.16 | | | | |
| F | ADD SH BASKET | IM UNDER HIN | GE: ADD HOLES FOR SPLIT LID | PH | 05.06.07 | | | |
| Ε | CHANG | E HINGE | CP | 01.04.19 | | | | |
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| MFG. A | PPR. | | D2221 | | SHEET 1 OF 5 | | | |
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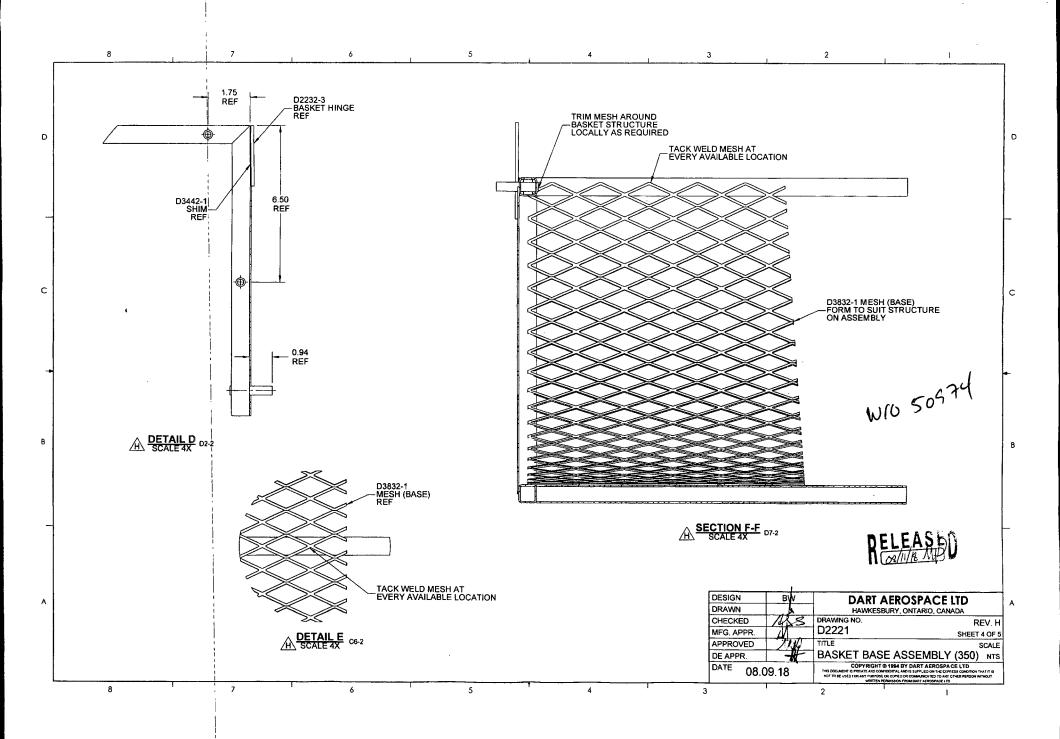


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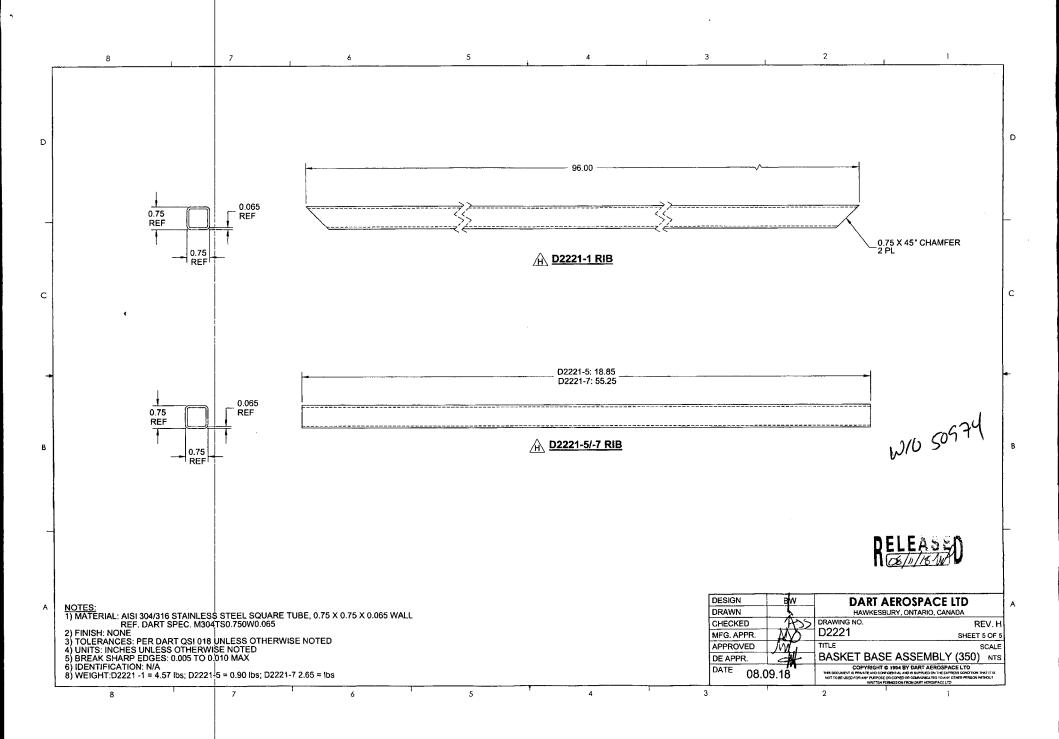
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